

Work Order ID 70745

Tuesday, June 14, 2011 10:03:35 AM



Page 1

Item ID: D4306-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: ME Date: 11-06-14

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4306

C

100

0.00



Large Fab

Large Fab

Memo

0.00

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on
side of tube when bending***
3- Trim access tube material to finish size as per dwg D4306

SAD 11-06-14

110

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

QC 11-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70745

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Item ID: D4306-1

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Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

SAC

11-06-14



130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15

11-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 14, 2011 10:03:33 AM

Page 1

Work Order ID: 70745



Parent Item: D4306-1



Parent Item Name: Rib

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

100

f

342.6410

4.1666

4.385895



SAD 11-06-14

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

307.3439

117029

17.2454

117690

91.3618

117775

198.7367

MAT034

35.2971

117337

35.2971

4.3859

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

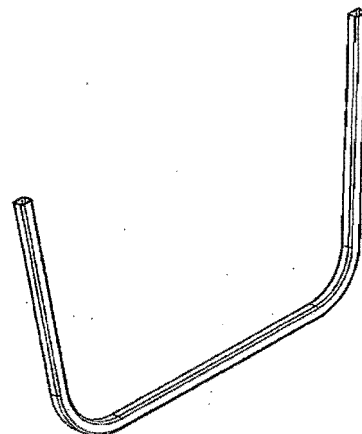
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

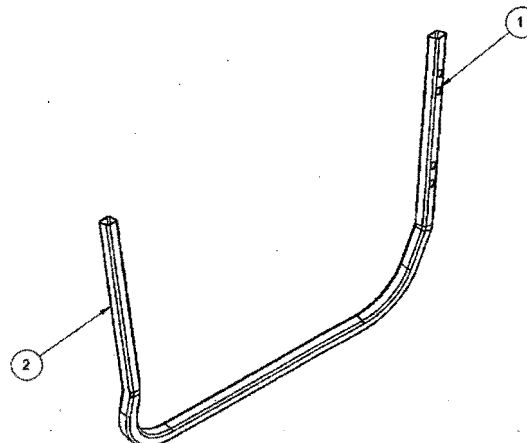
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

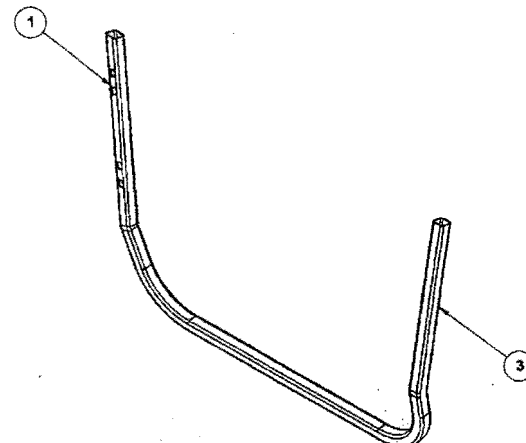
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



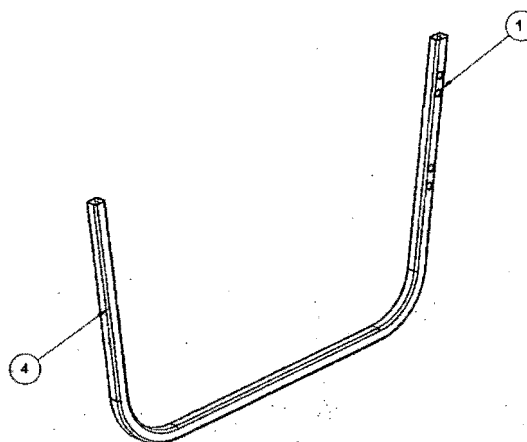
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A1-A4); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-A, C8-A, C1-A, C2-B), CHANGED CUT ANGLE FROM 19° TO 22° (B8-A, B1-B); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4306	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

RELEASED
2011-03-10

4 70745

